

Date: Thursday, 23/10/2008 10:54:06 AM  
 User: Julie Dawson

## Process Sheet

|                       |                                       |  |                  |  |  |
|-----------------------|---------------------------------------|--|------------------|--|--|
| Customer              | : CU-DAR001 Dart Helicopters Services |  | Drawing Name     | : 206/OH-58 SADDLE, INBOARD, LEFT SIDE |  |
| Job Number            | : 42886                               |  | Part Number      | : D29331UP                             |  |
| Estimate Number       | : 12925                               |  | Drawing Number   | : D2933 REV C                          |  |
| P.O. Number           | :                                     |  | Project Number   | : N/A                                  |  |
| This Issue            | : 23/10/2008 S.O. No. :               |  | Drawing Revision | : C                                    |  |
| Prsht Rev.            | : NC                                  |  | Material         | :                                      |  |
| First Issue           | : / / Type : MACHINED PARTS           |  | Due Date         | : 15/11/2008 Qty: 6 Um: Each           |  |
| Previous Run          | : 41722                               |  |                  |  |  |
| Written By            | :                                     |  |                  |  |  |
| Checked & Approved By | : <u>JUL 08-10-23</u>                 |  |                  |  |  |
| Comment               | : Est Rev:A New Issue 07-07-04 JLM    |  |                  |  |  |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description :  |
|---------|-----------------------|--|
| 1.0     | D6101001              | Saddle Billet  |
|         |                       |  |
|         |                       | <b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)<br>Issue material from stock: 7075-T7351 QQ-A-250/12<br>Cut Size 2.0 x 6.25 X 6.00<br>Grain Along Long 6.00 Length<br>Batch No: <u>B 34872</u>  |
| 2.0     | HAAS1                 | HAAS CNC VERTICAL MACHINING #1   |
|         |                       |  |
|         |                       | <b>Comment:</b> HAAS CNC VERTICAL MACHINING #1<br>Program part number and batch number.<br>1-Inspect part number and batch number are programmed correctly.<br>2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet<br>3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet<br>4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet<br>5-Deburr |
| 3.0     | MILLING CONV.         | CONVENTIONAL MILLING MACHINE   |
|         |                       |  |
|         |                       | <b>Comment:</b> CONVENTIONAL MILLING MACHINE<br>Machine Keyway and inspect per attached dimension sheet  |
| 4.0     | QC1                   | INSPECT ALL DIM TO DIM SHEET   |
|         |                       |  |
|         |                       | <b>Comment:</b> INSPECT ALL DIM TO DIM SHEET   |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Thursday, 23/10/2008 10:54:06 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 42886

Part Number: D29331UP

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

88 08/11/11

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



10X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MF 08/11/11

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSIÓN



88

Comment: INSPECT POWDER COAT

08-11-11

OK

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST423

88 08/11/12 OK

9.0 QC21 FINAL INSPECTION/W/O RELEASE



08/11/13 OK

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-12

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|   |  |  |              |         |
|---|--|--|--------------|---------|
| DART AEROSPACE LTD                          |  |  | Work Order:  | 42884   |
| Description: 206 Saddle, Inboard, Left side |  |  | Part Number: | D2933-1 |
| Inspection Dwg: D2933 Rev: C DSK: Rev:      |  |  | Page 1 of 1. |         |

### FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article  Prototype

|               |       |       |                | Record Actual Dimensions |       |       |       |   |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|---|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                        | 2     | 3     | 4     | 5 |
| A             | 0.100 | 0.140 |                | .120                     | .118  | .117  | .117  |   |
| B             | 0.100 | 0.140 |                | .121                     | .119  | .117  | .118  |   |
| C             | 0.100 | 0.140 |                | .120                     | .118  | .119  | .117  |   |
| D             | 0.210 | 0.230 |                | .219                     | .220  | .219  | .219  |   |
| E             | 1.245 | 1.255 |                | 1.250                    | 1.250 | 1.250 | 1.250 |   |
| F             | 1.245 | 1.255 |                | 1.250                    | 1.250 | 1.250 | 1.250 |   |
| G             | 2.495 | 2.505 |                | 2.500                    | 2.500 | 2.500 | 2.500 |   |
| H             | 0.510 | 0.515 |                | .511                     | .510  | .510  | .510  |   |
| I             | 1.572 | 1.582 |                | 1.577                    | 1.577 | 1.577 | 1.577 |   |
| J             | 2.495 | 2.505 |                | 2.500                    | 2.500 | 2.500 | 2.500 |   |
| K             | 0.257 | 0.262 |                | .258                     | .258  | .258  | .258  |   |
| L             | 0.312 | 0.317 |                | .314                     | .314  | .314  | .314  |   |
| M             | 0.235 | 0.240 |                | .238                     | .238  | .238  | .238  |   |
| N             | 0.100 | 0.140 |                | .108                     | .112  | .112  | .113  |   |
| O             | 0.540 | 0.560 |                | .551                     | .553  | .552  | .554  |   |
| P             | 0.490 | 0.510 |                | .500                     | .498  | .499  | .498  |   |
| Q             | 3.715 | 3.725 |                | 3.720                    | 3.720 | 3.720 | 3.720 |   |
| R             | 2.470 | 2.510 |                | 2.492                    | 2.492 | 2.492 | 2.492 |   |
| S             | 0.240 | 0.270 |                | .257                     | .257  | .256  | .255  |   |
| T             | 0.100 | 0.180 |                | .140                     | .140  | .140  | .140  |   |
| U             | 1.625 | 1.635 |                | 1.630                    | 1.630 | 1.630 | 1.630 |   |
| V             | 1.362 | 1.372 |                | 1.367                    | 1.367 | 1.367 | 1.367 |   |
| W             | 0.316 | 0.321 |                | .319                     | .319  | .319  | .319  |   |
| X             | 1.125 | 1.145 |                | 1.130                    | 1.132 | 1.132 | 1.133 |   |
| Y             | 1.565 | 1.585 |                | 1.579                    | 1.578 | 1.578 | 1.579 |   |
| Z             | 0.178 | 0.198 |                | .188                     | .188  | .188  | .188  |   |
| AA            |       |       |                |                          |       |       |       |   |
| AB            |       |       |                |                          |       |       |       |   |
| AC            |       |       |                |                          |       |       |       |   |
| AD            |       |       |                |                          |       |       |       |   |
| AE            |       |       |                |                          |       |       |       |   |
| Accept/Reject |       |       |                |                          |       |       |       |   |

|                     |     |       |          |
|---------------------|-----|-------|----------|
| Measured by:        | JL  | Date: | 08/11/09 |
| Audited by:         | 88  | Date: | 08/14/11 |
| Prototype Approval: | N/A | Date: | N/A      |

| Rev | Date     | Change   | Revised by | Approved |
|-----|----------|--|------------|----------|
| A   |          | New Issue  | RF         |          |
| B   | 02.12.12 | Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B | KJ/RF      |          |
| C   | 06.10.03 | Removed DT8683, DT8686 & DT8690                                | KJ/JLM     |          |
| D   | 07.03.21 | Revised per drawing revision C                                 | KJ/JLM     |          |
| E   | 08.01.16 | DT8695 A/B removed from dimension Y                            | KJ/EC/DD   | DA       |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|   |              |                   |
|---|--------------|-------------------|
| DART AEROSPACE LTD                          |              | Work Order: 42880 |
| Description: 206 Saddle, Inboard, Left side | Part Number: | D2933-1           |
| Inspection Dwg: D2933 Rev: C DSK: Rev:      |              | Page 1 of 1       |

### FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article  Prototype

| Dim | Min   | Max   | Go/No Go Gauge | Record Actual Dimensions |       |       |       |   |
|-----|-------|-------|----------------|--------------------------|-------|-------|-------|---|
|     |       |       |                | 1                        | 2     | 3     | 4     | 5 |
| A   | 0.100 | 0.140 |                | .117                     | .117  | .118  | .118  |   |
| B   | 0.100 | 0.140 |                | .118                     | .117  | .117  | .118  |   |
| C   | 0.100 | 0.140 |                | .117                     | .118  | .120  | .119  |   |
| D   | 0.210 | 0.230 |                | .219                     | .218  | .220  | .220  |   |
| E   | 1.245 | 1.255 |                | 1.250                    | 1.250 | 1.250 | 1.250 |   |
| F   | 1.245 | 1.255 |                | 1.250                    | 1.250 | 1.250 | 1.250 |   |
| G   | 2.495 | 2.505 |                | 2.500                    | 2.500 | 2.500 | 2.500 |   |
| H   | 0.510 | 0.515 |                | .570                     | .570  | .570  | .570  |   |
| I   | 1.572 | 1.582 |                | 1.577                    | 1.577 | 1.577 | 1.577 |   |
| J   | 2.495 | 2.505 |                | 2.500                    | 2.500 | 2.500 | 2.500 |   |
| K   | 0.257 | 0.262 |                | .258                     | .258  | .258  | .258  |   |
| L   | 0.312 | 0.317 |                | .314                     | .314  | .314  | .314  |   |
| M   | 0.235 | 0.240 |                | .238                     | .238  | .238  | .239  |   |
| N   | 0.100 | 0.140 |                | .112                     | .112  | .113  | .112  |   |
| O   | 0.540 | 0.560 |                | .551                     | .551  | .551  | .550  |   |
| P   | 0.490 | 0.510 |                | .498                     | .498  | .498  | .497  |   |
| Q   | 3.715 | 3.725 |                | 3.720                    | 3.720 | 3.720 | 3.720 |   |
| R   | 2.470 | 2.510 |                | 2.492                    | 2.492 | 2.492 | 2.492 |   |
| S   | 0.240 | 0.270 |                | .255                     | .254  | .255  | .254  |   |
| T   | 0.100 | 0.180 |                | .140                     | .140  | .140  | .140  |   |
| U   | 1.625 | 1.635 |                | 1.630                    | 1.630 | 1.630 | 1.630 |   |
| V   | 1.362 | 1.372 |                | 1.367                    | 1.367 | 1.367 | 1.367 |   |
| W   | 0.316 | 0.321 |                | .319                     | .319  | .319  | .319  |   |
| X   | 1.125 | 1.145 |                | 1.131                    | 1.132 | 1.132 | 1.133 |   |
| Y   | 1.565 | 1.585 |                | 1.576                    | 1.577 | 1.577 | 1.578 |   |
| Z   | 0.178 | 0.198 |                | .188                     | .188  | .188  | .188  |   |
| AA  |       |       |                |                          |       |       |       |   |
| AB  |       |       |                |                          |       |       |       |   |
| AC  |       |       |                |                          |       |       |       |   |
| AD  |       |       |                |                          |       |       |       |   |
| AE  |       |       |                |                          |       |       |       |   |

#### Accept/Reject

Measured by: J.L. Toml

Date: 08/11/07

Audited by: 88

Date: 08/11/11

Prototype Approval: N/A

Date: N/A

| Rev | Date     | Change   | Revised by | Approved |
|-----|----------|--|------------|----------|
| A   |          | New Issue  | RF         |          |
| B   | 02.12.12 | Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B | KJ/RF      |          |
| C   | 06.10.03 | Removed DT8683, DT8686 & DT8690                                | KJ/JLM     |          |
| D   | 07.03.21 | Revised per drawing revision C                                 | KJ/JLM     |          |
| E   | 08.01.16 | DT8695 A/B removed from dimension Y                            | KJ/EC/DD   | DS       |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|   |  |  |              |         |
|---|--|--|--------------|---------|
| DART AEROSPACE LTD                          |  |  | Work Order:  | 42886   |
| Description: 206 Saddle, Inboard, Left side |  |  | Part Number: | D2933-1 |
| Inspection Dwg: D2933 Rev: C DSK: Rev:      |  |  | Page 1 of 1  |         |

### FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article  Prototype

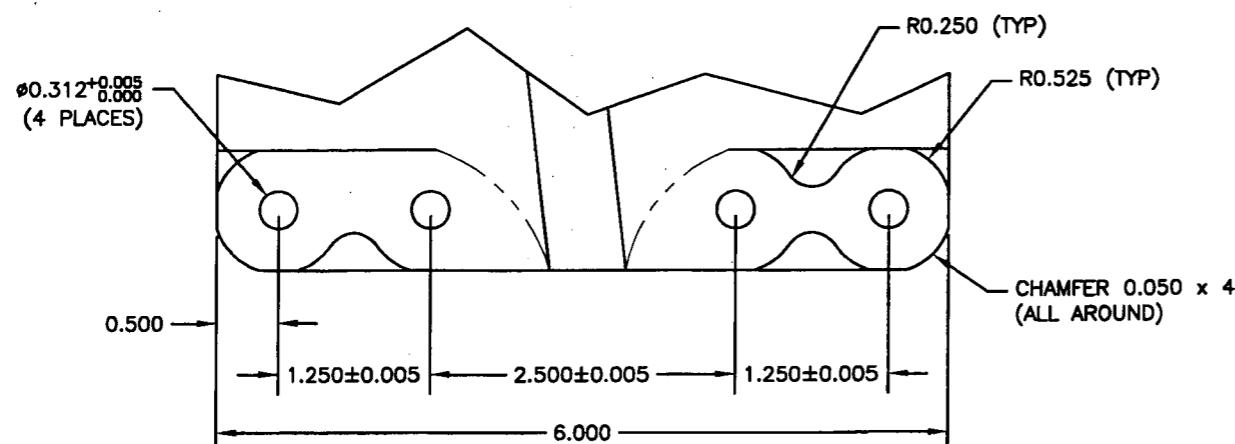
| Dim | Min   | Max   | Go/No Go Gauge | Record Actual Dimensions |       |   |   |   |
|-----|-------|-------|----------------|--------------------------|-------|---|---|---|
|     |       |       |                | 1                        | 2     | 3 | 4 | 5 |
| A   | 0.100 | 0.140 |                | .118                     | .118  |   |   |   |
| B   | 0.100 | 0.140 |                | .118                     | .117  |   |   |   |
| C   | 0.100 | 0.140 |                | .120                     | .118  |   |   |   |
| D   | 0.210 | 0.230 |                | .219                     | .220  |   |   |   |
| E   | 1.245 | 1.255 |                | 1.250                    | 1.250 |   |   |   |
| F   | 1.245 | 1.255 |                | 1.250                    | 1.250 |   |   |   |
| G   | 2.495 | 2.505 |                | 2.500                    | 2.500 |   |   |   |
| H   | 0.510 | 0.515 |                | .570                     | .570  |   |   |   |
| I   | 1.572 | 1.582 |                | 1.577                    | 1.577 |   |   |   |
| J   | 2.495 | 2.505 |                | 2.500                    | 2.500 |   |   |   |
| K   | 0.257 | 0.262 |                | .258                     | .258  |   |   |   |
| L   | 0.312 | 0.317 |                | .314                     | .314  |   |   |   |
| M   | 0.235 | 0.240 |                | .238                     | .238  |   |   |   |
| N   | 0.100 | 0.140 |                | .112                     | .113  |   |   |   |
| O   | 0.540 | 0.560 |                | .550                     | .551  |   |   |   |
| P   | 0.490 | 0.510 |                | .495                     | .495  |   |   |   |
| Q   | 3.715 | 3.725 |                | 3.720                    | 3.720 |   |   |   |
| R   | 2.470 | 2.510 |                | 2.492                    | 2.492 |   |   |   |
| S   | 0.240 | 0.270 |                | .253                     | .254  |   |   |   |
| T   | 0.100 | 0.180 |                | .140                     | .140  |   |   |   |
| U   | 1.625 | 1.635 |                | 1.636                    | 1.630 |   |   |   |
| V   | 1.362 | 1.372 |                | 1.367                    | 1.367 |   |   |   |
| W   | 0.316 | 0.321 |                | .319                     | .319  |   |   |   |
| X   | 1.125 | 1.145 |                | 1.132                    | 1.132 |   |   |   |
| Y   | 1.565 | 1.585 |                | 1.577                    | 1.577 |   |   |   |
| Z   | 0.178 | 0.198 |                | .188                     | .188  |   |   |   |
| AA  |       |       |                |                          |       |   |   |   |
| AB  |       |       |                |                          |       |   |   |   |
| AC  |       |       |                |                          |       |   |   |   |
| AD  |       |       |                |                          |       |   |   |   |
| AE  |       |       |                |                          |       |   |   |   |

#### Accept/Reject

|              |              |       |          |
|--------------|--------------|-------|----------|
| Measured by: | <i>JL PM</i> | Date: | 08/11/07 |
| Audited by:  | <i>JL</i>    | Date: | 08/11/11 |

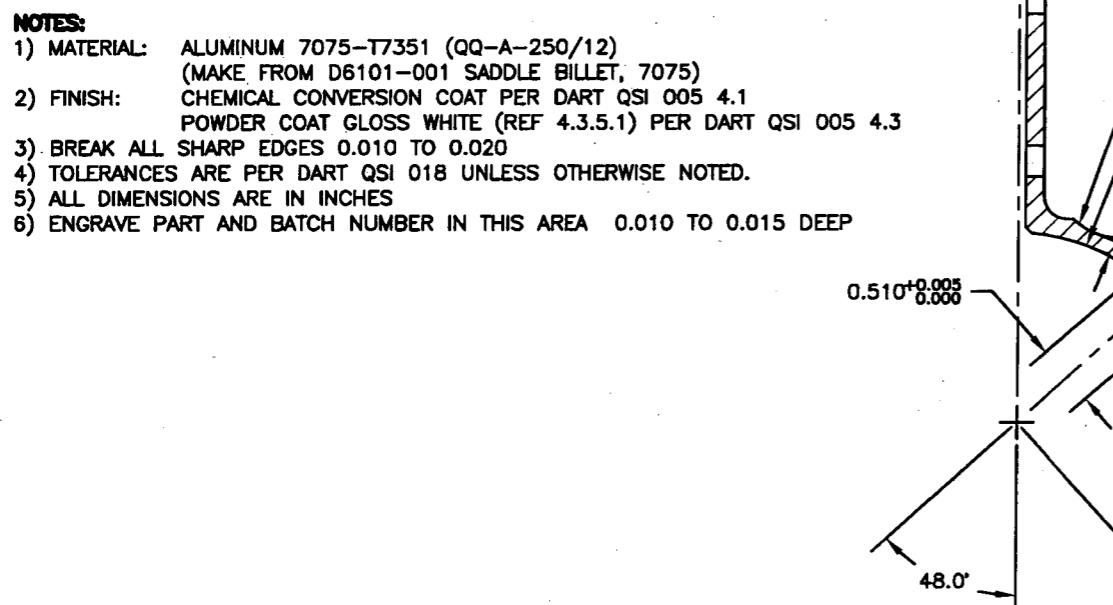
|                     |     |       |     |
|---------------------|-----|-------|-----|
| Prototype Approval: | N/A | Date: | N/A |
|---------------------|-----|-------|-----|

| Rev | Date     | Change   | Revised by | Approved  |
|-----|----------|--|------------|-----------|
| A   |          | New Issue  | RF         |           |
| B   | 02.12.12 | Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B | KJ/RF      |           |
| C   | 06.10.03 | Removed DT8683, DT8686 & DT8690                                | KJ/JLM     |           |
| D   | 07.03.21 | Revised per drawing revision C                                 | KJ/JLM     |           |
| E   | 08.01.16 | DT8695 A/B removed from dimension Y                            | KJ/EC/DD   | <i>AS</i> |

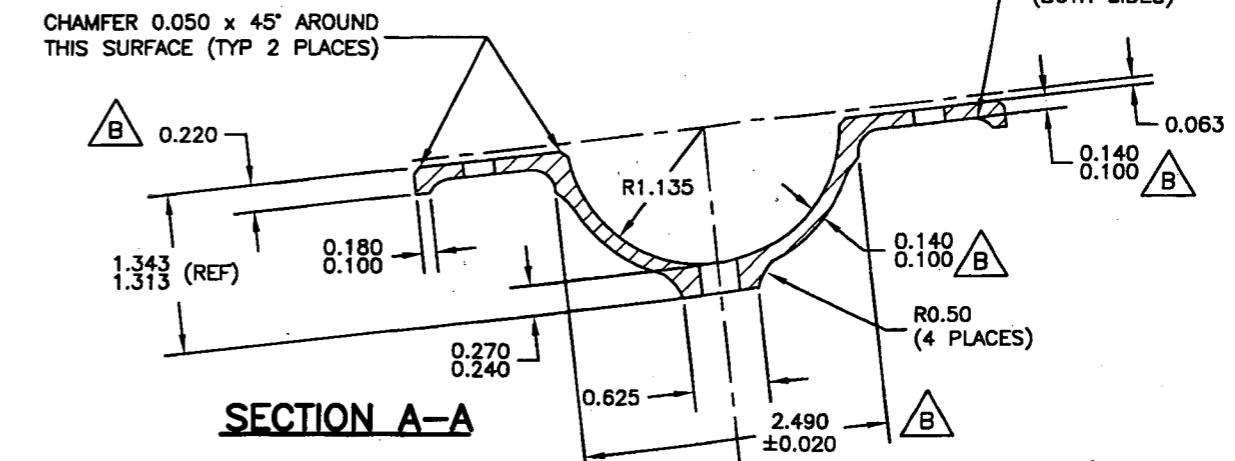


VIEW C-C

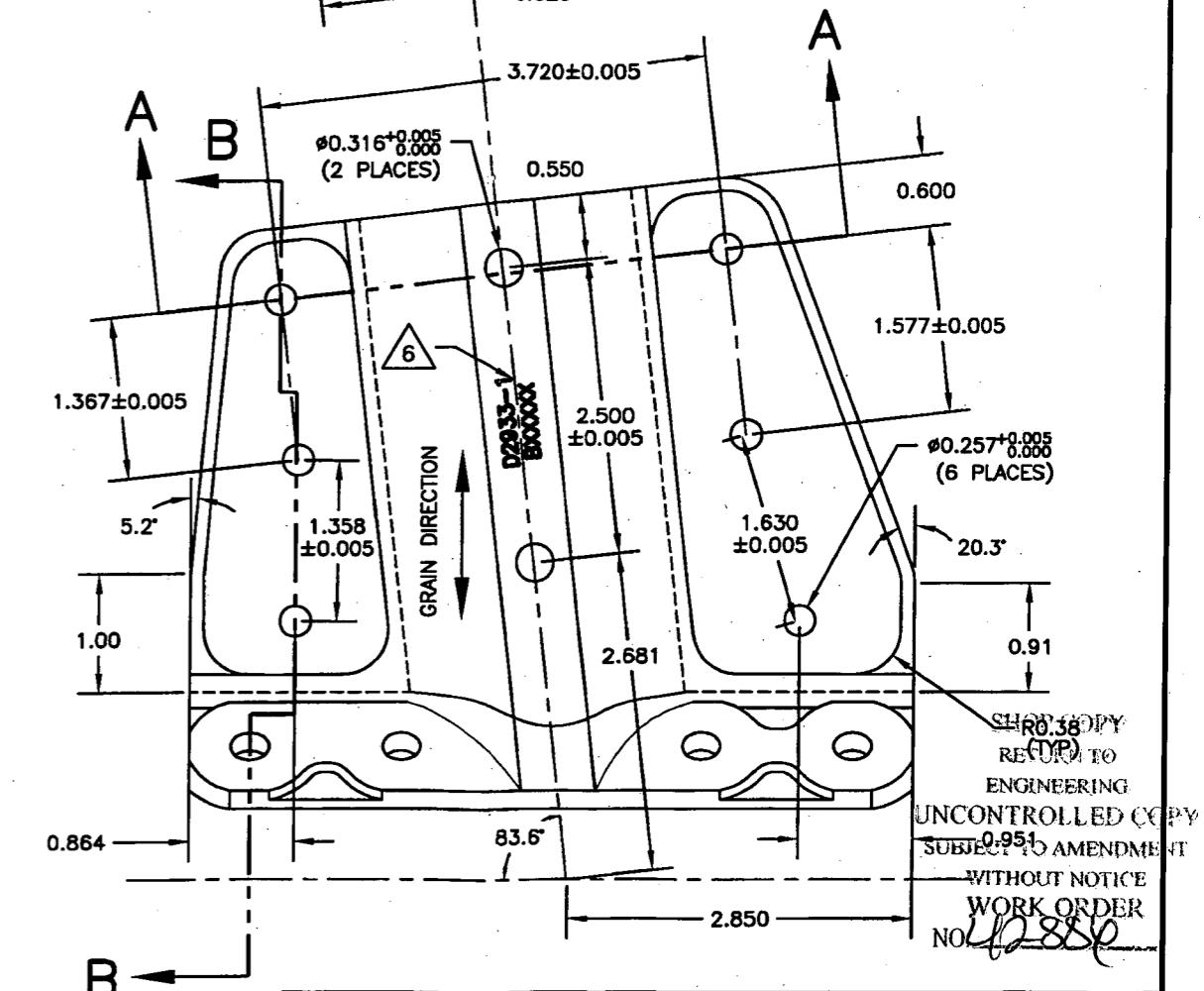
D2933-1 LH SADDLE (SHOWN)  
D2933-2 RH SADDLE (OPPOSITE)



SECTION B-B



SECTION A-A



|   |          |                               |
|---|----------|-------------------------------|
| C | 06.11.09 | R0.188 WAS R0.30 TO R0.25     |
| B | 00.05.29 | CHANGED GEOMETRY AND MATERIAL |
| A | 99.10.29 | NEW ISSUE                     |

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PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE USA, INC.

|          |               |             |  |
|----------|---------------|-------------|--|
| DESIGN   | DRAWN BY      | DART        | DART AEROSPACE USA, INC.<br>BELLEVUE, WA |
| CHECKED  | APPROVED      | DRAWING NO. | REV. C                                   |
| PH       | H             | D2933       | SHEET 1 OF 1                             |
| DATE     | TITLE         | SCALE       | 2:3                                      |
| 06.11.09 | SADDLE INSIDE |             |  |

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07.02.12

